



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.4001

Job Sheet 204314



Part No: 646.4001

Job Qty: 1 pcs

Part Name: AS350 Cable Cutter System



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/6/19

Job Tracking No:

Due Date: 1/24/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C1 IPP REV:A 12.10.23 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.08 AS PER DWG REV.B
DD VERF:JLM IPP REV:C 16.01.07 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs		1/24/20	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com



Container No: S260510



Part: 646.4001

Job No: 204314

Serial No/Batch: S260510

Revision:

Inspector:

Exp Date: 38/01/2020

					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
120 QC 4	1 pcs	1/24/20	0.00	0.00	QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	JRB
					QC 4 - 9	
					QC 4 - 46	
					QC 4 - 68	
					QC 4 - 72	
					QC 4 - 74	
					QC 4 - 75	
					QC 4 - 78	
130 Packaging 3-1 - Stock - B4B	1 pcs	1/24/20	0.00	0.00	Packaging 3 - 1 - B4B	JRB
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
135 DC - 1 - B4B	1 pcs	1/24/20	0.00	0.00	DC - 1 - B4B	
					DC - 2 - B4B	
140 QC 21 - FG	1 pcs	1/24/20	0.00	0.00	QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - FG - 53	

Part Op 110 - pick kit
 Descriptions: 120 - QC4- 100% Inspect kits for completeness

- 130 - Identify and pack for shipping as per PPP 646.4001 Location: _____
 135 - Document Control - Photocopy bluefile & type labels per PPP 646.4001
 140 - QC21- Final Inspection - Work Order Release

014721

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0129	VHB Tape	8 ft (8 ea)	110-Packaging 1 - Pick Kit	5215203
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5241630
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5241651
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5253461
600.1013	021200-3M Tape Primer 94 Primer 24216	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5221172
646.2910	Deflector	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5220095
646.3001	Lower Cable Cutter Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5243880
646.3110	Channel	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5233062
646.3210	Support	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5221454
646.3301	Upper Cutter Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5255306
646.3510	Strut	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5218952
646.3511	Strut	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5183035
646.3610	Filler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5230345
646.3710	Doubler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5214284
646.3711	Clip	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5218358
646.3712	Clip	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5219276
646.3713	Gusset	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5219291
646.3714	Gusset	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5197814
646.3715	Strut Doubler	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5218112
646.3716	Gauge Bracket	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5233850
646.3717	Doubler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5238110
646.3718	Custom Washer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5219261
646.3719	Doubler	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5218795
646.3810	Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5220046
646.3811	Radius Block	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5229075
646.3812	Gusset Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5220084
646.3813	AS350 Strut Bracket	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5171341
646.3910	Shim	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5218108
646.3911	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5185805
646.3912	Shim	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5218106
646.3913	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5218110
646.9410	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5056998
647.0112	Strut Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5258631
647.7703	Strut Assembly	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5243472
650.9201	Eyelet Bracket Assembly	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5239706
AN3-11A	Bolt	10 Ea (10 ea)	110-Packaging 1 - Pick Kit	5249339
AN3-12A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5169226
AN3-13A	Bolt	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5258738
AN3-3A	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5253401
AN3-4A	Bolt	10 Ea (10 ea)	110-Packaging 1 - Pick Kit	5253408
AN3-5A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5216385-1
AN3-6A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5194345
AN316C4R	Nut, Jam	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5227999
AN44-5A	Eyebolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5216370
AN4C7A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5222451
AN665-34R	Clevis	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5239635-1
CCR264SS3-02	Cherry Rivet	36 Ea (36 ea)	110-Packaging 1 - Pick Kit	5218602
CR3213-5-3	Cherry Rivet	14 Ea (14 ea)	110-Packaging 1 - Pick Kit	5231329
MS20426AD5-7	Rivet	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	52133922-36
MS20470AD5-5-5	Rivet	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5155675
MS20470AD5-6	Rivet	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5048897
MS20470AD5-7	Rivet	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	5203251
MS21042L08	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5250462
MS21042L3	Nut	63 Ea (63 ea)	110-Packaging 1 - Pick Kit	5248081
MS21042L4	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5225039
MS21047-3	Nut Plate	18 Ea (18 ea)	110-Packaging 1 - Pick Kit	5216288

MS24693-C278	Screw	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5202672
MS24694-S51	Screw	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5155669
MS24694-S54	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5225823
MS24694-S55	Screw	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	5247925
MS27039-08-13	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5247871
MS27039-1-10	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5231296
MS27039-1-12	Screw	6 Ea (6 ea)	110-Packaging 1 - Pick Kit	5231298
MS27039-1-16	Screw	24 Ea (24 ea)	110-Packaging 1 - Pick Kit	5235395
MS27039-1-19	Screw	22 Ea (22 ea)	110-Packaging 1 - Pick Kit	5123443
MS27039-1-20	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5228511
MS27039-1-21	Screw	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5171793
NAS1149F0332P	Washer (AN960-10L)	144 Ea (144 ea)	110-Packaging 1 - Pick Kit	5237779
NAS1149F0363P	Washer (AN960-10)	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5075330
NAS1149F0432P	Washer (AN960-416L)	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5235429
NAS1149FN832P	Washer (AN960-8)	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5248080

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	600.0129	8	386	0
	600.0990	1	28	0
	600.0991	1	28	0
	600.1012	1	33	0
	600.1013	5	95	0
	646.2910	1	14	0
	646.3001	1	5	0
	646.3110	1	28	0
	646.3210	1	23	0
	646.3301	1	6	0
	646.3510	1	30	0
	646.3511	1	32	0
	646.3610	1	25	0
	646.3710	1	19	0
	646.3711	1	28	0
	646.3712	1	33	0
	646.3713	1	31	0
	646.3714	1	32	0
	646.3715	2	32	0
	646.3716	1	46	0
	646.3717	1	42	0
	646.3718	2	53	0
	646.3719	2	36	0
	646.3810	2	45	0
	646.3811	1	40	0
	646.3812	2	48	0
	646.3813	1	38	0
	646.3910	4	64	0
	646.3911	1	48	0
	646.3912	4	61	0
	646.3913	1	25	0
	646.9410	1	42	0
	647.0112	2	66	0
	647.7703	2	18	0
	650.9201	2	24	0
	AN3-11A	10	309	0
	AN3-12A	2	101	0
	AN3-13A	1	68	0
	AN3-3A	4	397	0
	AN3-4A	10	319	0
	AN3-5A	2	199	0
	AN3-6A	2	180	0
	AN316C4R	2	85	0
	AN44-5A	2	41	0
	AN4C7A	2	217	0
	AN665-34R	2	67	0
	CCR264SS3-02	36	964	0
	CR3213-5-3	14	402	0
	MS20426AD5-7	2	545	0
	MS20470AD5-5-5	8	713	0
	MS20470AD5-6	8	550	0

MS20470AD5-7	3	1,002	0
MS21042L08	2	1,098	0
MS21042L3	63	1,410	0
MS21042L4	2	4,158	0
MS21047-3	18	395	0
MS24693-C278	5	156	0
MS24694-S51	5	270	0
MS24694-S54	2	296	0
MS24694-S55	3	158	0
MS27039-08-13	2	258	0
MS27039-1-10	2	334	0
MS27039-1-12	6	327	0
MS27039-1-16	24	488	0
MS27039-1-19	22	369	0
MS27039-1-20	2	131	0
MS27039-1-21	4	83	0
NAS1149F0332P	144	5,671	0
NAS1149F0363P	2	255	0
NAS1149F0432P	4	1,251	0
NAS1149FN832P	4	2,216	0

Part Specifications

Specifications could not be found.

Plex 12/6/19 9:48 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APCAL INDUSTRIES, INC. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE EXPLICIT WRITTEN PERMISSION OF APCAL INDUSTRIES, INC. IS PROHIBITED.

NOTES:

1. AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND FILLET EDGES.
2. INSTALL F/N 14 WITH F/N 52 & 53.
3. 3M VHB ADHESIVE TAPE .025" THICK X .50" WIDE
VENDOR: MCMASTER-CARR P/N 75935A651.
4. 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE.
VENDOR: R.S. HUGHES P/N 021200-24216.
5. REUSE FASTENERS FROM F/N 1.
6. USE WASHERS A/R AS SHIMS TO OBTAIN BEST FITMENT.
7. AT CUSTOMERS OPTION, INSTALL F/N 65 BY MATCH DRILLING ON TO F/N 1.
8. INSTALL SHIM IF OEM PROVISIONS ARE INSTALLED ON AIRCRAFT. REMOVE SHIM LAYERS TO ACHIEVE CORRECT SIZE. MATCH DRILL HOLES. USE F/N 78 SCREW IN PLACE OF F/N 17 SCREW.
9. NEWER INSTALLATIONS ON AIRCRAFT WITH UPDATED CANOPY MAY REQUIRE DIFFERENT LENGTH SCREWS. USE F/N 62 TO REPLACE F/N 44 & F/N 26 IN PLACE OF F/N 41 WHEN NECESSARY.

UNINCORPORATED ECN(S)

05304

	5		5		5	78	601.3875	SCREW		UNINCORP. 
	1		1		1	77	646.9410	SHIM		
			4		4	76	601.2764	WASHER	NAS1149F030P	
			2		2	75	601.2973	LOCKNUT	MS21042-06	
			2		2	74	601.2988	SCREW	MS27039-0813	
			2		2	73	601.2943	LOCKNUT	MS21042-3	
			2		2	72	601.3128	NUT	AN316C4R	
			2		2	71	601.3209	LOCKNUT	MS21042-4	
			4		4	70	601.2638	WASHER	NAS1149F0430P	
			2		2	69	601.2669	BOLT	ANAC7A	
			2		2	68	601.3119	CLEVIS	AN365-34R	
			2		2	67	601.3121	EYE BOLT	AN44-5A	
			2		2	66	650.9201	EYE BRACKET ASSY		
	REF	REF		REF		65	647.5701	GPS MOUNT KIT		
				2		64	601.3151	WASHER	NAS1149F030P	
					2	63	601.2911	SCREW	MS24494553	
			24		24	62	601.2637	SCREW	MS27039-1-16	
	2		2		2	61	601.2763	BOLT	AN3-12A	
			1		1	60	646.3913	SHIM		
			4		4	59	646.3912	SHIM		
			1		1	58	646.3911	SHIM		
			4		4	57	646.3910	SHIM		
			5		5	56	600.1013	PRIMER		
	8 FT			8 FT		55	600.0129	VHB TAPE		
			1		1	54	600.1012	SEALANT	PR-1425 CLASS B	
			1		1	53	600.0991	MAGNABOND 6398 PART B		
			1		1	52	600.0990	MAGNABOND 6398 PART A		
	6		10		10	51	601.2826	BOLT	AN3-17A	
				2		50	646.3814	WIPER BRACKET		
				2		49	601.2910	SCREW	MS27039-1-18	
		2		2		48	601.1365	SCREW	MS27039-1-10	
		2		2		47	646.3719	DOUBLER		
		2		2		46	646.3718	CUSTOM WASHER		
		1		1		45	646.3717	DOUBLER		
		22		22		44	601.1948	SCREW	MS27039-1-19	
		2		2		43	601.1952	SCREW	MS27039-1-20	
		4		4		42	601.1956	SCREW	MS27039-1-21	
4006	4005	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	MATL	SPEC.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
A	INCORPORATED ECNS 02199, 02351, 02719 & 02745	02/08/2010	F. BEAVO
B	INCORPORATED ECN 03046, 03049 & 04731	17/04/2014	F. BEAVO
C	INCORPORATED ECN 05098	09/09/2015	F. BEAVO